

Date: Friday, 19/10/2007 2:54:46 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR FWD RH
Job Number : 35247	
Estimate Number : 11234	
P.O. Number :	Part Number : D32812
This Issue : 19/10/2007 S.O. No. :	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/10/2007 Type : THERMOFORMING	Drawing Revision : B
Previous Run : 35083	Material :
Written By :	Due Date : 25/10/2007 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 4865
 Description: Floor Protector Fwd, RH
 Possible Supplier: Delastek
 Certificate of Conformity is required

C 207/10/22 (4)

2.0	D32812P	Floor Protector, Fwd RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
 Floor Protector Fwd, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

C 7/10/25 (4)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
 Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

C 7/10/25 (x4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST260

(x4)

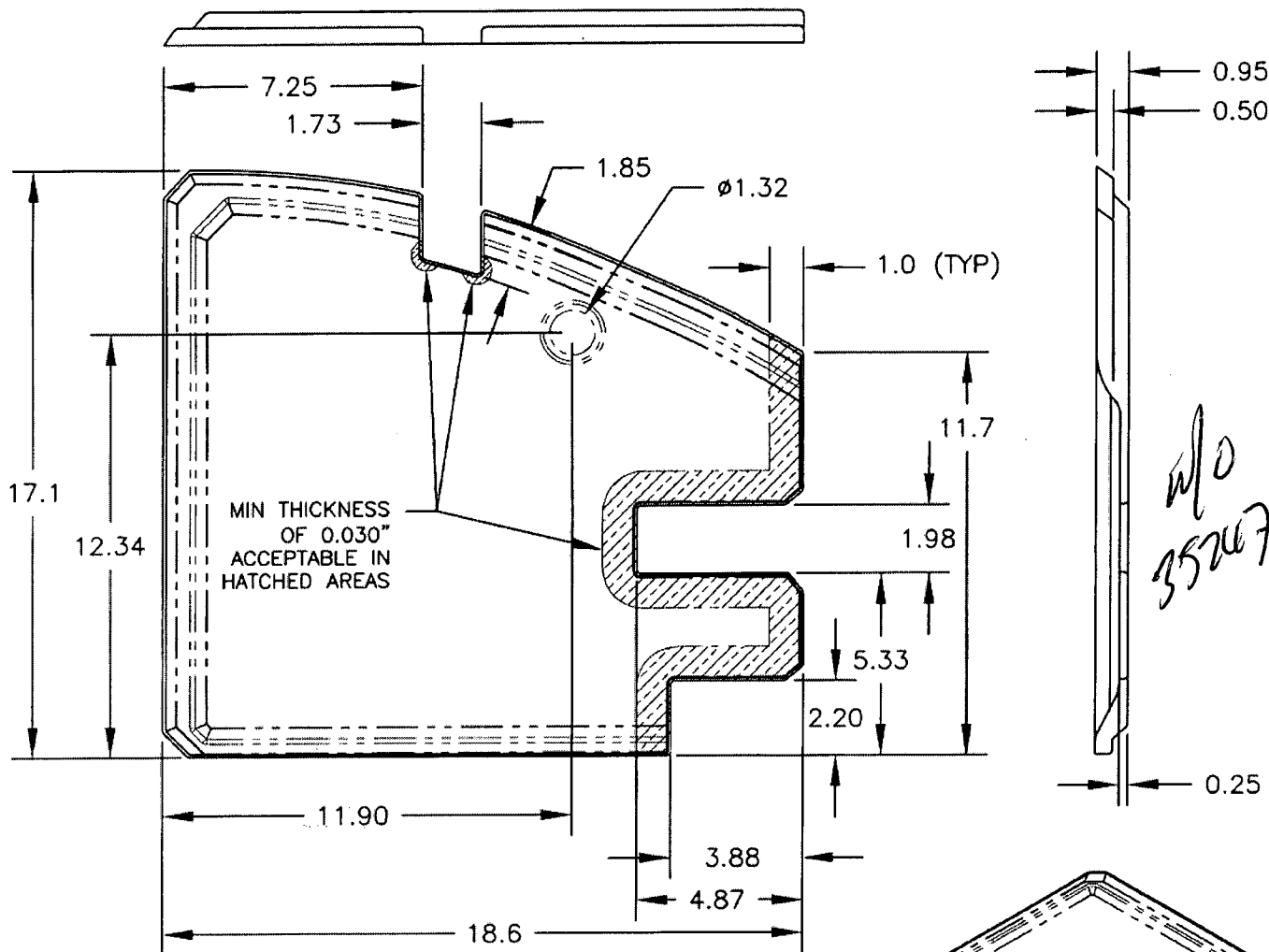
07/10/30

AS

AS



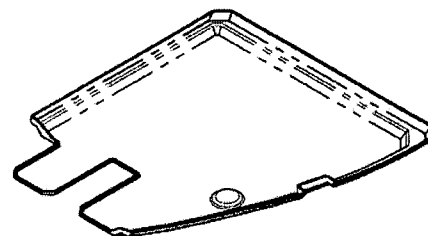
DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HH	APPROVED	HH	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE	05.11.25			TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03			NEW ISSUE	
B	05.11.25			NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01

UNDER REVIEW

07.10.05 LE
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AND SHIP



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NO. 35247

D3281-1 FLOOR PROTECTOR, FWD LH

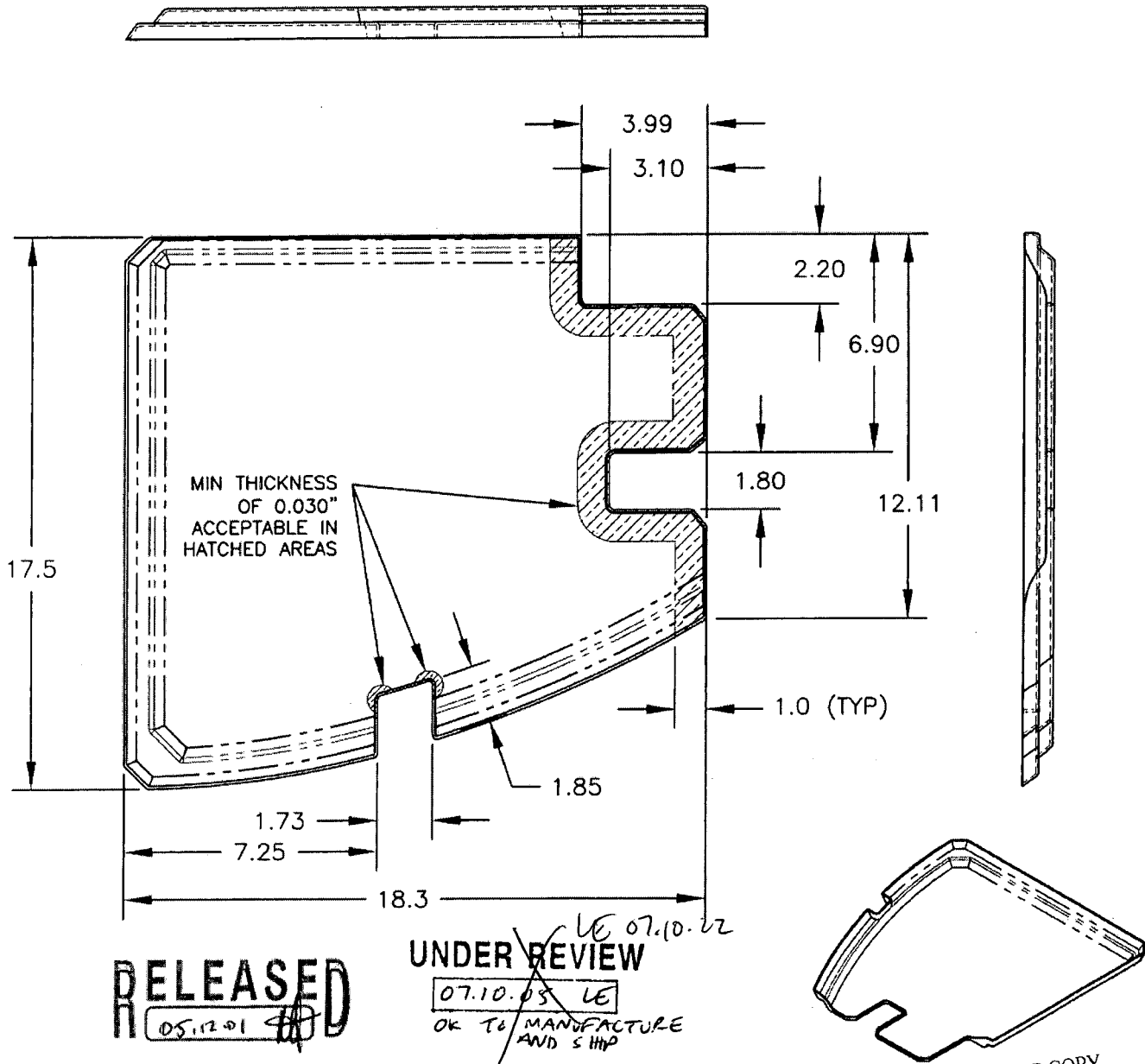
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01 *HA*

UNDER REVIEW

07.10.05 LE
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AND SHIP

D3281-2 FLOOR PROTECTOR, FWD RH

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

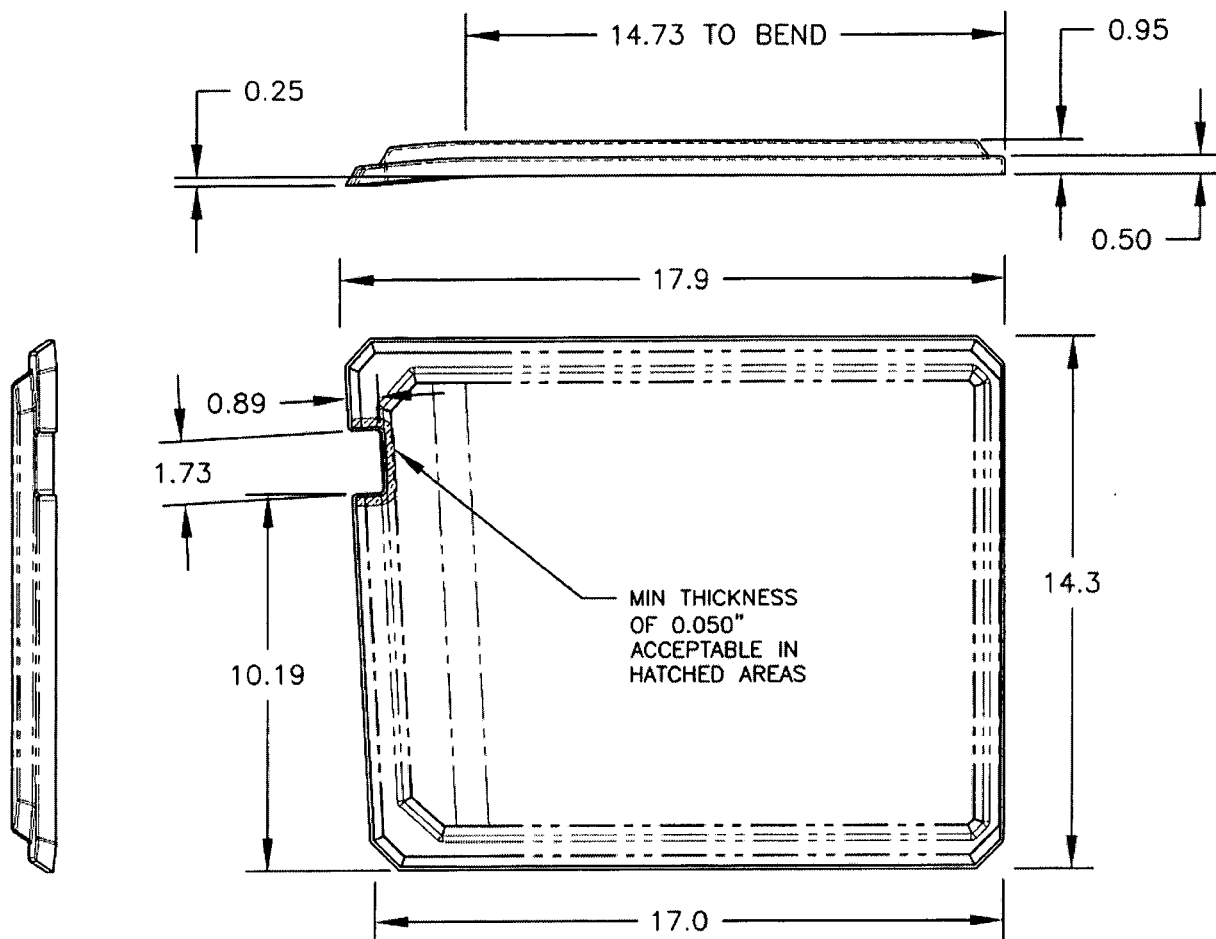
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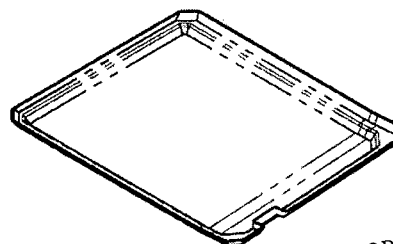
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01

UNDER REVIEW
07.10.22

07.10.05 LE
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AND SHIP



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Date: Mercredi, 2007-02-07 13:19:02
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
 Numéro Job : 40953
 Numéro Soumission : 2384
 Numéro B.A. :
 Cette fois : 2007-02-07 No. B.V. :
 Prsht Rev. : NC
 Prem. fois : - - Type :
 Job précédente : 40355

Nom Dessin : FLOOR PROTECTOR
 Numéro Article : DKC134-0045
 Numéro Dessin : D3281
 Projet Numéro : DKC134
 Révision dessin : B
 Matériel : F6006
 Date Due : 2007-02-14

Qté: 20 JdM: UNITE

Écrit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce: D3281-2



SN: B30659

Process Sheet Rév.: 00 Création du premier

Produit additionnel

À THERMOFORMER Pl. 28.02.07

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total : 3.340 UNITE(s)

Lexan F6006 Noir N° 700 48" x 96"

APL0016

N° de Lot:



3-5913-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Bon achat: 5913

2.0 SÉCHAGE/ ANEAL



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
 SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5516

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 12-2-07 Sceau:

Quantité: Date: Sceau:



Date: Mercredi, 2007-02-07 13:19:02
Initiateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40953

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0045

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-2 à l'aide du moule N° D3281-2T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 12-2-07 Sceau:



Quantité: Date: Sceau:

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-2 à l'aide du gabarit de trimage N° D3281-2T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 23-2-07 Sceau:



Quantité: Date: Sceau:

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 27/2/07 Sceau:



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Date: Mercredi, 2007-02-07 13:19:02
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40953

Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0045

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-2

N° de Job: 40953

Date de fabrication: 23-2-07

Sceau d'inspection.

Quantité: 20

Date: 23-2-07

Sceau:



Quantité:

Date:

Sceau:

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-2

Date de fabrication:

N° de job:

Quantité: 20

Date: 27/2/07

Sceau:



Quantité:

Date:

Sceau:



DELASTEK COMPOSITES INC.
2699, Sième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12223
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

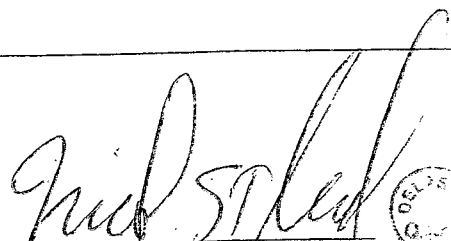
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
24/10/2007	22/10/2007	5510	C. LAVOIE		PO000004865		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
4	0	4	DKC134-0044	Floor Protector Fwd LH Part 1 N° D32811P B35246 Selon dessin D3281 Rev.: B Job: 40952 U de M : Ea			
4	0	4	DKC134-0045	Floor Protector Fwd RH Part 2 N° D32812P B35247 Selon dessin D3281 Rev.: B Job: 40953 U de M : Ea			
4	0	4	DKC134-0046	Floor Protector Aft LH Part 3 N° D32813P B35248 Selon dessin D3281 Rev.: B Job: 40954 U de M : Ea			
4	0	4	DKC134-0047	Floor Protector Aft RH Part 4 N° D32814P B35249 Selon dessin D3281 Rev.: B Job: 40957 U de M : Ea			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:



Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.